Birch Saddle

Work Order ID 122817

July-28-14 12:52:49 PM

122817

Item ID: D4894-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: C

Item Name: Fwd Beam **Stop** *NS2*

Start Date: 7/28/14 **Start Qty:** 1.00 *1*

Required Date: 8/08/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ✓ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Draw Nbr	Revision Nbr
D4894	B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							DAS 23 9-89 14-07-29
100 Waterjet	**Memo**	0.00				1	0		
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89 14-07-29
110 QC	**Memo**	0.00				1	0		
Quality Control									
114		0.00							DAS 20 9-89 14-08-01
114 Mill Conv	**Memo**	0.00				1	0	JCL	
Conventional Milling Machine	DRILL HOLES AS PER DWG								

Item ID: D4894-1
Revision ID:
Item Name: Fwd Beam
Start Date: 7/28/14 **Start Qty:** 1.00 *1*
Required Date: 8/08/14 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Cust Item ID:
Customer:

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
116	QC2- Inspect parts off machine FAI/FAIB	0.00				1	ϕ		J.C.L 14/08/01 DAS 20 9-89 14-08-01
116 QC Quality Control	**Memo**	0.00							
120	QC8- Inspect parts - second check	0.00				1	ϕ		DAS 08 9-89
120 QC Quality Control	**Memo**	0.00							
130	Chemical Conversion Coat per QSI005 4.1 NC BRAKE	0.00				1			DAS 41 9-89 14-8-11
130 HandFinish Hand Finishing	**Memo**	0.00							

J.a 14/08/11

QC7

1 — — DAS 38 9-89 14/08/11

Item ID: D4894-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Beam
Start Date: 7/28/14 **Start Qty:** 1.00 *1*
Required Date: 8/08/14 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
131	~~White Gloss~~(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							DAS
131	127892					1			41
Powdercoat	**Memo**	0.00							~~9-89~~
Powder Coating	ATTN: SANDTEX BLACK MASK AS PER NOTE 8								14-8-11
	START TIME: 400 OVEN TEMPERATURE: 320 FINISH TIME: 430								
132	QC3- Inspect Part Finish	0.00							
132						1	~~6~~	(2)	14/08/12.
QC	**Memo**	0.00							
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	**Memo**	0.00							
Quality Control									

NA

14/8/12

Item ID: D4894-1
Revision ID:
Item Name: Fwd Beam
Start Date: 7/28/14 **Start Qty:** 1.00 *1*
Required Date: 8/08/14 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100*
Setup Start *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location:_____	0.00							
150 Packaging Packaging	**Memo** PPP 122811	0.00				1X	DAS 28 9-89	AUG 12 2014	
160	QC21- Final Inspection - Work Order Release	0.00							
160 QC Quality Control	**Memo**	0.00				MLJ	14-08-12		

MLJ 14-08-12

Picklist Print

July-28-14 12:52:49 PM

Work Order ID: 122817

122817

Parent Item: D4894-1

D4894-1

Parent Item Name: Fwd Beam

Start Date: 7/28/14 **Required Date:** 8/08/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A 13.05.27 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X06.000		Purchased	No				f	33.7500		5			DAS 23 8-8

M6061T6B1.000X06.000

6061T6 BAR 1.00 X 6.00

**

14-07-29.

Location	Loc Qty	Loc Code	
MAT003	33.75		
m125771	2		
m127797	2.55		
m129530	3.2		
m129639	26		129639

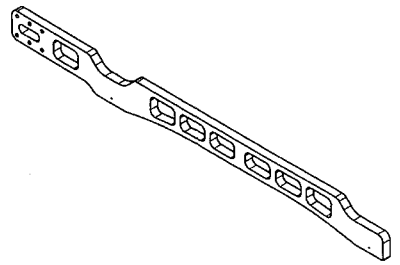
DART AEROSPACE LTD	Work Order:	12247
Description: Fwd Beam	Part Number:	D4894-1
Inspection Dwg: D4894 **Rev:** A		Page 1 of 1

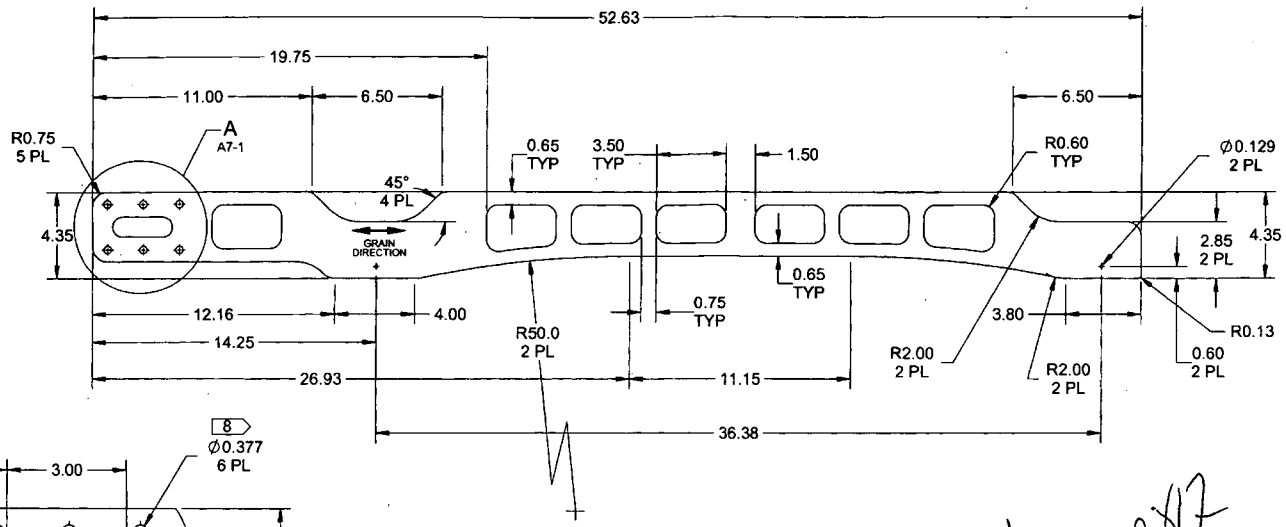
FIRST ARTICLE INSPECTION CHECKLIST

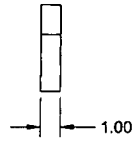
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.63	+/-0.030	52.63"	–		T	Jkm07
19.75	+/-0.030	19.75"	–		T	
11.00	+/-0.030	11.00"	–		V	Jkm08
6.50	+/-0.030	6.50"	–		V	Jkm01
0.65	+/-0.030	0.642"	✓		V	
3.50	+/-0.030	3.498"	–		V	
1.50	+/-0.030	1.488"	–		V	
6.50	+/-0.030	6.50"	–		V	
4.35	+/-0.030	4.35"	–		V	
2.85	+/-0.030	2.840"	–		V	
3.80	+/-0.030	3.80"	–		V	
12.16	+/-0.030	12.16"	–		T	
4.00	+/-0.030	4.00"	–		V	
mill 14.25	+/-0.030	(See other FAI)				
mill 0.60	+/-0.030					
mill 36.38	+/-0.030					
mill Ø0.129	+0.005/-0.001					
1.00	+/-0.030	1.013"	–		V	
mill 0.60	+/-0.030	(See other FAT)				
mill 2.300	+/-0.010					
mill 0.75	+/-0.030					
mill 1.800 Pitch	+/-0.005					
mill 3.600	+/-0.005					
mill Ø0.377	+0.006/-0.001					

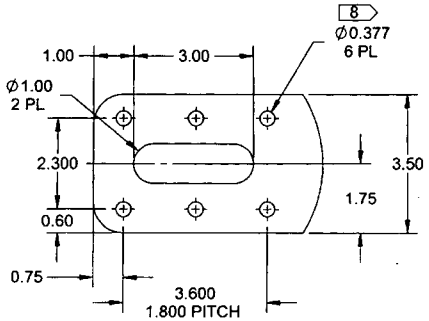
Measured by:	DAS 23 9-89	Audited by:	DA 08 9-8	Preliminary Approval:	
Date:	14-07-29	Date:	14/08/11	Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	









DETAIL A D7-1

D4894-1 FWD BEAM

WO 122817

RELEASED
2014-07-24

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 11.96 lbs
8) MASK HOLES PRIOR TO POWDER COAT

REV.	DESCRIPTION	BY	DATE
B	REMOVED ONE Ø0.129 HOLE FROM D4894-3 (ZN D2-2)	RF	14.06.24
A	NEW ISSUE	RF	13.05.24

APPROVED

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	VS	DRAWING NO. D4894 REV. B
MFG. APPR.	JLM	SHEET 1 OF 2
APPROVED	HS	TITLE BEAM SCALE NTS
DE APPR.	DS	
DATE	14.06.24	

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DART AEROSPACE LTD	Work Order:	
Description: FWD Beam	Part Number:	D4894-1
Inspection Dwg: D4894 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.377	+0.006 -0.001	0.380	✓		Caliper	JCL-08
0.75	+/- 0.030	0.760	✓		"	
1.800 (pitch)	+/- 0.005	1.802	✓		"	
3.600	+/- 0.005	3.604	✓		"	
0.60	+/- 0.030	0.591	✓		"	
2.300	+/- 0.005	2.304	✓		"	
Ø 0.129	+0.005 -0.001	0.130	✓		"	
14.25	+/- 0.030	14.260	✓		"	A 1000
36.38	+/- 0.030	36.360	✓		Tape	~~Tape~~ JCL-09
0.60	+/- 0.030	0.597	✓		Caliper	JCL-08

Measured by:	J.C.L.		Audited by:		DAS 08 9-89	Preliminary Approval:	
Date:	14/08/01	14-08-01	Date:	14/08/11		Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: D4894-1 B

Part No. 122817 F

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	X
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐
Machining	X	Small Fab	☐	Prod. Eng. Coor.	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐
Large Fab	☐	Composite	☐	Supplier	☐
Engineering	☐				
Quality	☐				
Other	☐				

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	X	14/8/11	100	1	Slot near holes is off center by 0.039 RC moved when Blanks were cut / Programming	DAS 12 9-89 14/8/11	Acceptable. Not critical section per SR-D117-837-1. Still stronger than nearby sections by inspection	DAS 12 9-89 14/8/11	D.A 14/08/11 DAS 08 9-89	DAS 16 9-89 14/08/11
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐	Bending
☐	Centre Not Concentric
☐	Cracks
☐	Crimp/Kink/Ripple/Wave
☐	Cuffs
☐	Crushing
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Marks/Chatter
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend
☐	BOM/Route
☐	Broken/Damage/Defect
☐	Burrs
☐	Contamination
☐	Countersink
☐	Cut Too Short
X	Drawing
☐	Drill Holes
☐	Finish
☐	Fit/Function

☐	Folio/Program
☐	Grain
☐	Hardware
☐	Inspection Incomplete/Unqualified
☐	Instructions Incomplete/Unclear
☐	Misaligned/off center
☐	Mislabeled
☐	Misread
☐	Off-set
☐	Out of Calibration
☐	Out of Sequence

☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Positioned Wrong
☐	Power Loss/Surge

☐	Pressure/Forced
☐	Set-up
☐	Temperature/Cure
☐	Weld
☐	Wrong Stock Pulled
☐	Other

_____

_____

_____